

Date: Thursday, 05/06/2008 1:17:50 PM
 User: Linda Lacelle

Process Sheet

FOR ENGINEERING USE ONLY

| | | | |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : COMFORT SEAT- FRAME |
| Job Number | : 39728 | | |
| Estimate Number | : 13369 | | |
| P.O. Number | : | Part Number | : D37521 |
| This Issue | : 05/06/2008 S.O. No. : | Drawing Number | : D3752 PROTOTYPE 08.06.09 |
| Prsht Rev. | : NC | Project Number | : 00079 |
| First Issue | : / / Type : THERMOFORMING | Drawing Revision | : A |
| Previous Run | : | Material | : |
| Written By | : <u>W</u> | Due Date | : 12/06/2008 Qty: 2 Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est. REV: A New Issue 08.06.03 DL | | |

Additional Product

PROTOTYPE

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|------------------------------|
| 1.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |



Comment: HAND FINISHING THERMOFORMING

Set up machine program ~~D3774-1~~ ^{D3752-1} DL
 Set up clamping frame as per folio

| | | |
|-----|------------------|-------------------------|
| 2.0 | MLEXS125F6002904 | GE PLASTICS LEXAN SHEET |
|-----|------------------|-------------------------|



x2.

Comment: Qty.: 10.6670 sf(s)/Unit Total : 21.3340 sf(s)

GE PLASTICS LEXAN SHEET

M105330

DL

08.06.05

| | | |
|-----|----------------|------------------------------|
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 08.06.05

| | | |
|-----|---------------|-----------------------|
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. A
 Folio Rev. A.

DL 08.06.05

Date: Thursday, 05/06/2008 1:17:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT- FRAME

Job Number: 39728

Part Number: D37521

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ENGINEERING

08.06.05

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/06/05 (2)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/06/05 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08.06.05 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Project 00079A

CP 08.06.05 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.09 Penelope

Job Completion



mf 08-07-03

| | | |
|-------------------------|------------------|----------------------|
| DART AEROSPACE LTD | | WORK ORDER: 79728 #1 |
| Description: Seat Frame | | Part Number: D3752-1 |
| Inspection Dwg: D3752 | Rev: A Prototype | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | PR |
| Free of visual flaws (bumps, cracks, voids, etc.) | PR |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3752 Rev. A and record below

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|-----------------|
| 0.050" | MIN | 0.060" | | | | |
| 0.060" | MIN | 0.067" | | | | |
| 0.030" 0.025" | MIN | 0.034" | | | | Measured 0.025" |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Measured by: DT
Date: 08/06/05

Audited by: [Signature]
Date: 08/06/05

Prototype Approval: [Signature]
Date: 08-06-05

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |



ATTN: CHANTAL

GE Polymershapes

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER: PO00004161

OUR SHIPPER NO: 078178

LINE ITEM # 1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 125 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25. 853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

JON CALDWELL
BRANCH MANAGER

Receiving Report

Date: 07/08/16 Batch No: M105330

Supplier: GE Polymershapes Dart P/O: 4161

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒
 Release Note Attached: Yes ☐ No ☒ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection Co Hook N/A ☒
 Work Order N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12

Production/Admin:
 Date 07/08/16
 Received/Costing RIP 5411
 Initial 62

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

** PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION**
 THANK YOU
 EMAIL/FAX INFO

PLEASE Remit To: GE Polymershapes 9150 Airport Road Brampton ON L6S 6G1 Tel: 905-789-3111 Fax: 905-789-3122
 NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

0.050 MIN THICKNESS ALONG TOP EDGE

HEAVY HAIRCELL TEXTURE ON THIS SIDE

0.025 MIN THICKNESS IN THIS AREA (CORNER)

0.060 MIN THICKNESS ALONG BOTTOM EDGE

Ø0.219 (7/32 DRILL)
TYP 8 PLS

19.6 REF

30.3 REF

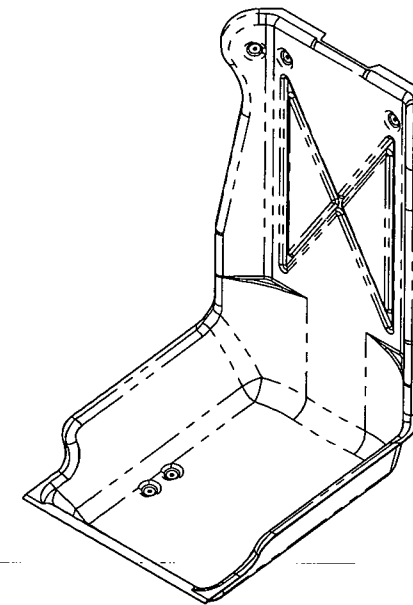
18.2 REF

6

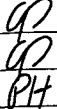
D3752-1 SEAT FRAME

NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.06.09

| | | | |
|--|---|--|------------------------|
| A | NEW ISSUE | CP | 08.04.25 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | DRAWING NO. D3752 | REV. A SHEET 1 OF 1 |
| DATE | 08.04.25 | TITLE SEAT FRAME | SCALE NTS |
| COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

| | | | |
|-------------------------|-------|--------------|-------------|
| DART AEROSPACE LTD | | WORK ORDER: | 39728 #2 |
| Description: Seat Frame | | Part Number: | D3752-1 |
| Inspection Dwg: | D3752 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | dh |
| Free of visual flaws (bumps, cracks, voids, etc.) | dh |
| | |
| | |

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3752 Rev. A and record below

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| 0.050" | MIN | 55" | ✓ | | | |
| 0.060" | MIN | 62" | ✓ | | | |
| 0.025" | MIN | 28" | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | |
|-------------------------|--------------------------------|--|
| Measured by: <u>dh.</u> | Audited by: <u>[Signature]</u> | Prototype Approval: <u>[Signature]</u> |
| Date: <u>08.06.06</u> | Date: <u>08.06.09</u> | Date: <u>08.06.09</u> |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |